

DART AEROSPACE LTD

Work Order:

22835A

Description: Ø3.250 Support

Part Number:

D2940-1

Dwg: D2940 Rev. A1

Qty:

10 4

Page 1 of 1






RF  
13.06.09

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller. Blank size makes (2) D2940-1 <b>Dwg not required</b>	RF	05.03.23	10
2	PG	Issue P/O: 7004787 Description: D6104-007 Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104 <b>Material release note required.</b>	U	05.03.24	10
3	RG	Receive and Inspect for raw material dimensions. <b>Ensure material release note is attached.</b>	CR	05.04.01	10
4	MS	Turn blank for Haas as per Folio FA079	E	05.05.12	4
5	QC1	Inspect all dimensions as per Dwg D2940	E	05.05.12	4
6	MV	Machine as per Folio FA079	E	05.05.12	4
7	MV	Tumble & Deburr	E	05.05.13	4
8	QC1	Inspect all dimensions to inspection sheet as per Dwg D2940	E	05.05.13	4
9	QC8	Inspect dimensions for second check	SD	05.05.13	4
10	FP	Powder Coat White (4.3.5.2) per QSI 005 4.3	FF	05/05/16	4
11	QC3	Inspect Powder Coat	W	05 05 16	4
12	ST	Identify and stock	DP	05/5/17	4
13	AC	Cost / part 207.55	SAC	05.05.18	4
14	DC	Close W/O 207.55 Inspect Level 21	RF	05.05.20	4

Rev	Date	Change	Revised By	Approved
A	01.01.08	Preliminary Issue	EC	
B	01.08.15	Removed Heat treating	EC	
C	02.11.26	Reformat; Added P/O	KJ / RF	RF

RELEASED  
05/11/24 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.05.13	3	Chamber on edge too deep, see attached details and authorisation, 2 parts affected	 05.05.17	OK per DS, see attached	 05.05.17	 05.05.17	 05.05.17	 05.05.17

Part No: D2940-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 05/05/2017

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	22835
<b>Description:</b> Ø3.250 Support		<b>Part Number:</b>	D2940-1
<b>Inspection Dwg:</b> D2940 Rev. A1		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	3.211	3.216	3.215	3.215					
B	4.946	4.966	4.959	4.958					
C	0.718	0.738	0.727	0.728					
D	0.090	0.110	0.103	0.100					
E	3.564	3.584	3.571	3.570					
F	0.022	0.042	0.032	0.032					
G	3.444	3.464	3.451	3.450					
H	0.112	0.132	0.119	0.120					
I	2.170	2.190	2.180	2.180					
J	4.451	4.471	4.459	4.460					
K	0.413	0.433	0.425	0.426					
L	0.913	0.933	0.930	0.929					
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250				
AB	0.490	0.510		0.50	0.50				
AC	0.140	0.160		0.150	0.150				
AD	3.510	3.530		3.529	3.529				
AE	1.633	1.673		1.670	1.671				
AF	1.493	1.513		1.510	1.511				
AG	0.040	0.060		0.047	0.048				
AH	0.188	0.193	DT8706	0.188	✓	—			
AI	0.140	0.160		0.149	0.150				
AJ	2.518	2.538		2.521	2.520				
AK	0.040	0.060		0.048	0.048				
AL	0.010	0.020		0.010	0.015				
AM	0.140	0.160		0.154	0.145				
AN	0.350	0.450		0.360	0.360				
AO	0.240	0.260		0.260	0.250				
AP	0.150	0.170		0.168	0.168				
AQ	0.053	0.073		0.063	0.063				
AR	101.64	105.64	DT8698	✓	✓				
AS	0.257	0.262	DT8683	✓	✓				
AT	0.053	0.073		0.063	0.063				
AU	4.118	4.138		4.126	4.126				
AV									
AW									
Accept/Reject									

Measured by:	S.G.
Date:	05/05/11

Audited by:	SA
Date:	05.05.26

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	RF



GLORIA MATERIAL TECHNOLOGY CORP.

# INSPECTION CERTIFICATE

台南縣新營市新中路35號1樓  
1FL, NO.35, HSIN CHUNG RD, HSIN YING,  
TAINAN, TAIWAN, ROC

TEL: (06)6520000  
FAX: (06)6520088

Messrs: PROGRESSIVE ALLOY STEEL UNLIMITED L.L.C.

Order No: 2004003262

Grade: 17-4PH

P.O. NO.: 3370

FILE NO: 2004004782-A

Size: 4-1/2"

Date: 11/30/2004

HEAT-Lot No: S2301-40

Weight: 1026.0KG

P'cs: 3

Condition: HF-Solution Annealed-Peeled

Chemical Composition (wt%)									
	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Min.					0.015	3.00	15.00		3.00
Max.	0.07	1.00	1.00	0.040	0.030	5.00	17.50	0.50	5.00
Result	0.03	0.36	0.64	0.021	0.023	4.48	15.79	0.13	3.25

Mechanical Properties Spec.				
	Hardness (1/2R)	Grain Size	$\delta$ -Ferrite	H900-Hardness(Avg)
Spec.Min.				40HRC
Spec.Max.	363HB		5%	47HRC
Result	333HB	7.5	0.64%	45.1HRC

Tensile Test				
	Elongation(A)	Tensile Strength(Rm)	Yield Strength(Rp)	Reduction of Area(Z)
Unit	%	KSI	KSI	%
Min.	10	190	170	40
Max.				
Result	20	210	184	53

Non-Metallic Inclusions : (AMS 2303C)		
	Severity	Frequency
Max.	0.35	0.4
Result	0	0

## Specification:

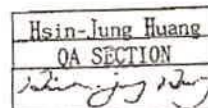
- 1.ASTM A484M-03a, A564M-04, A370-03a.
- 2.ASME SA484 (1998), SA564 (1998).
- 3.AMS 5643Q, 2303C(Magnetic Particle Test).
- 4.EN 10204/3.1.B.
- 5.UNS S17400.
- 6.SAE AMS-H-6875.

Remark:



Our quality and environment management system have been certified by ISO9001 QMS and 14001EMS  
We hereby certify that the material described herein has been manufactured and tested with satisfactory result in accordance with the requirement of  
the above material specification We hereby Inspection Certificate comply with EN10204 3.1.B.

Date: 3-29-05  
Cust: DART AEROSPACE  
W/O: 23023  
Qty: 235  
☒ Size ☐ Special Instructions  
☒ Part # ☒ Alloy ☒ Heat Lot  
These test reports are for material shipped  
on your PO# 474984  
From TMX Copper & Brass Sales  
Quality Representative: P. M. Cadney  
Customer Part #







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台南縣新營市新中路35號1樓  
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TEL: (06) 6520000  
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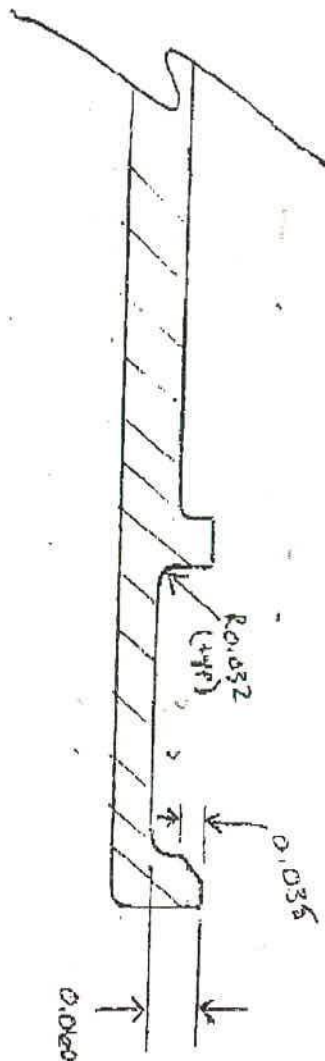
Condition: HF-Solution Annealed-Peeled

1. MANUFACTURING PROCESS: EAF+LHF+VOD, FORGED OR HOT ROLLED.
2. SOLUTION TREATMENT: 1900F FOR 30 MIN/INCH PLUS ONE ADDITIONAL HOUR (MINIMUM ONE HOUR), RAPIDLY COOLED TO BELOW 90F.
3. MATERIAL IS FREE FROM KNOWN CONTACT WITH MERCURY AND RAIUM.
4. MATERIAL IS FREE FROM WELDS OR WELD REPAIRS.
5. ULTRASONIC TEST: OK.
6. MACRO/MICRO OK.
7. MECHANICAL PROPERTIES TESTED AS PER H900 CONDITION.
8. REDUCTION RATION 4:1 MIN
9. FURNACES CALIBRATED TO MIL-H-6875.



Our quality and environment management system have been certified by ISO9001 QMS and 14001EMS.  
We hereby certify that the material described herein has been manufactured and tested with satisfactory result in accordance with requirement of  
the above material specification. We hereby Inspection Certificate comply with EN10204 3.1 B.

Hsin-Jung Huang  
QA SECTION  
*[Signature]*



Chamfer blends into R0.032 rad.  
 No flat between chamfer & radius.

05.05.12

ACCEPTABLE  
 DEMAND

05.05.12

ATTACH TO WORK ORDER